DEPARTMENT OF TRANSPORTATION
DIVISION OF ENGINEERING SERVICES
Office of Structural Materials
Quality Assurance and Source Inspection

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Contract #: 04-0120F4
Cty: SF/ALA Rte: 80 PM: 13.2/13.9
File #: 82.28

WELDING INSPECTION REPORT

Resident Engineer: Siegenthaler, Peter
Address: 333 Burma Road
City: Oakland, CA 94607

Report No: WIR-026065
Date Inspected: 08-Aug-2011

Project Name: SAS Superstructure
Prime Contractor: American Bridge/Fluor Enterprises, a JV
Contractor: Westmont Industries

OSM Arrival Time: 630
OSM Departure Time: 1500
Location: Santa Fe Springs, CA

CWI Name: Ruben Dominguez
CWI Present: ☑ Yes ☐ No

Inspected CWI report:	☐ Yes	☑ No	☐ N/A	**Rod Oven in Use:**	☑ Yes	☐ No	☐ N/A
Electrode to specification:	☑ Yes	☐ No	☐ N/A	**Weld Procedures Followed:**	☑ Yes	☐ No	☐ N/A
Qualified Welders:	☑ Yes	☐ No	☐ N/A	**Verified Joint Fit-up:**	☑ Yes	☐ No	☐ N/A
Approved Drawings:	☑ Yes	☐ No	☐ N/A	**Approved WPS:**	☑ Yes	☐ No	☐ N/A
				Delayed / Cancelled:	☐ Yes	☑ No	☐ N/A

Bridge No: 34-0006 L & R
Component: Maintenance Travelers

Summary of Items Observed:

On this date, Caltrans Quality Assurance Inspector (QA) Sherri Brannon is present at the Westmont Industries (WMI) jobsite in Santa Fe Springs, California for the purpose of observing fabrication and QC functions for the SAS Superstructure, Bid Item #99, Maintenance Traveler and Bid Item #100, Maintenance Traveler (Bike Path).

E2/E3 Bike Path Traveler

This QA Inspector made random shop observations and observed no fit-up performed on the E2/E3 Bike Path Traveler Assemblies on this date.

SAS-WB Traveler – Lower Truss Frame Assembly

Welding Completed on the SAS-WB Traveler – Lower Truss Frame Assembly on Thursday 5-12-11. Quality Control Mr. Dominguez informed QA Inspector that Smith Emery did complete visual inspection and waiting on WMI to weld and grind on some area's found by visual inspection. Grinding not completed on this date.

E2/E3-WB Traveler (South)

This QA Inspector randomly observed WMI production personnel Mr. Richard Fuentes WID #3201 and one helper, performing layout, fitting and tack welding activities at various locations for the E2/E3-WB Traveler Assemblies. This QA Inspector observed Mr. Fuentes performing the FCAW in all positions randomly throughout the shift.

SAS-WB Traveler - Fixed Stair Section

This QA Inspector observed WMI production welder Mr. Daniel Grayum (WID # 3049) continuing to perform

Flux Core Arc Welding (FCAW) activities on the SAS-WB Traveler assemblies. This QA Inspector observed Mr. Grayum performing the FCAW in all positions randomly throughout the shift.

This QA Inspector observed WMI production welder Mr. Charles Newton (WID # 3200) continuing to perform Flux Core Arc Welding (FCAW) activities on the SAS-WB Traveler Assemblies. This QA Inspector observed Mr. Newton performing the FCAW in all positions randomly throughout the shift.

This QA Inspector randomly observed WMI production personnel Mr. Jose Rodriguez (WID # 3031) performing layout, fitting and tack welding activities at various locations for the SAS-WB Traveler Assemblies. This QA Inspector observed Mr. Rodriguez performing the FCAW in all positions randomly through the shift.

E2/E3-WB Traveler (North)
This QA Inspector randomly observed WMI production personnel Mr. Cesar Canales WID #3195 and helper Mr. Jesus Rayas WID#3197, performing layout, fitting and tack welding activities at various locations for the E2/E3 Traveler Assemblies. This QA Inspector observed Mr. Canales performing the FCAW in all positions randomly throughout the shift.

This QA Inspector randomly observed WMI production welder Mr. Eutimo Lopez (WID # 3035) continuing to perform Flux Core Arc Welding (FCAW) activities on the E2/E3-WB Traveler Assemblies. This QA Inspector observed Mr. Lopez performing the FCAW in all positions on tube steel and plate material, randomly throughout the shift.

This QA Inspector randomly observed that Smith Emery, CWI, QC Inspector Mr. Ruben Dominguez was present, during the above mentioned welding and fitting activities. During random observation, this QA Inspector observed that the applicable WPS's and copies of the shop drawings, appeared to be located near each work station, where the above mentioned welding and fitting activities were being performed. This QA Inspector randomly verified that the consumable material, utilized during the welding appeared to be in compliance with the applicable WPS and that the above mentioned welders were currently qualified for the applicable process and position of welding. This QA Inspector randomly observed QC Inspector Mr. Dominguez verifying the in-process welding parameters, including voltage, amperage, pre-heat and travel speed and the parameters appeared to be in compliance to the applicable WPS.

This QA Inspector observed that the activities mentioned above, appeared to be in compliance with the contract requirements and this QA Inspector observed no non-conforming issues, on this date.

RPI Coating (Blast and Paint)
QA Inspector was informed by RPI Coating Quality Control (QC) Representative Mr. Miguel Nunez that RPI is going to be performing sample tests using International Interzinc 22HS Inorganic Zinc-Rich Silicate and was given product data sheets of the for International Paint system. Later in the morning this QA Inspector randomly observed that RPI coating personnel performing abrasive blasting activities on the seven (7) trolley links assemblies. After abrasive blasting was completed, QA Inspector then observed RPI (QC) performing surface profile checks on the abrasive blasted base metal surfaces. This QA Inspector also, observed Mr. Nunez utilizing Testex Press-O-Film and a micrometer to perform the tests. During observation, this QA Inspector observed that the readings appeared to be 3.2 mils, 3.5 mils, and 3.4 mils. This QA Inspector noted that the contract requires a

surface profile of 1.5 mils, (40 um) - 3.4mils (86um) and that the above mentioned tested profile appears to be in compliance with the contract requirements. This QA Inspector was then informed by Mr. Nunez that primer application will start when the International Paint Representative arrives. Later in the afternoon this QA Inspector met with RPI Coating Representatives Mr. Carlos Torres and Mr. Gary McDonald and International Paint Representative Mr. Marc Dyer.

QA Inspector observed Mr. Nunez breaking down the Interzinc 22HS kit to start priming process. After mixing the Interzinc 22HS Mr. Nunez tried to spray the prime coating on the wall in the paint booth and decided that the prime was not flowing through the spray gun and ask the International Paint Representative about adding thinner. Mr. Dyer stated that RPI could at 10 percent. Mr. Nunez added 10 percent thinner to the prime coating mix. After mixing the thinner Mr. Nunez realized that RPI coating had not picked up the wrong thinner for the prime coating application. The thinner RPI purchased was for the International Interfine 979 Acrylic Polysiloxane top coat application. Mr. Nunez when informed QA Inspector that RPI would have to order the thinner for the International Interzinc 22HS Inorganic Zinc-Rich Silicate and that RPI will set up the test again when the thinner arrives. QA Inspector informed SMR Mr. Nicolai Hvass of the above information.

Summary of Conversations:

As stated within this report.

Comments

This report is for the purpose of determining conformance with the contract documents and is not for the purpose of making repair or fit for purpose recommendations. Should you require recommendations concerning repairs or remedial efforts please contact Nina Choy (510) 385-5910, who represents the Office of Structural Materials for your project.

Inspected By:	Brannon,Sherri	Quality Assurance Inspector
Reviewed By:	Lanz,Joe	QA Reviewer